Qty:

Tuesday, 9/11/2007 10:55:36 AM

User:

Chantal Lavoie

**Process Sheet** 

Customer Job Number

AIA:

**Estimate Number** 

: 34540 : 12957

P.O. Number

AIA:

This Issue

: 9/11/2007

A ( 12): .oN .O.2

Prsht Rev. First Issue

Type

: SMALL/MED FAB

**Part Number Drawing Number** 

**Drawing Name** 

**Project Number** 

: N/A : U/Ŕ **Drawing Revision** 

Material **Due Date** 

: 9/18/2007

: D3639 UNDER REVIEW

: STIFFNER

: D36393

10 Um:

Each

Written By

Checked & Approved By

Comment

**Previous Run** 

New Issue 07-07-20 JLM : Est Rev:A

Verified By:EC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

M2024T3S050 1.0



0.4491 sf(s)/Unit %Total : Comment: Qty.:

2024-T3 .050 sheet Batch:

4.4909 sf(s) m105 646

2024-T3 .050 sheet

2.0



Comment: FLOW WATER JET

1-Cut as per Dwg D3639

Dwg Rev: preL Prog Rev: PPEL 1B07-09-19

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



1807-09-19



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK



SMALL FAB





Comment: SMALL & MEDIUM FAB RESOURCE 1



Page 1

Form: rprocess

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CH	ANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
,												
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date 01/10/25
			QA: N/C C	losed:	Date:

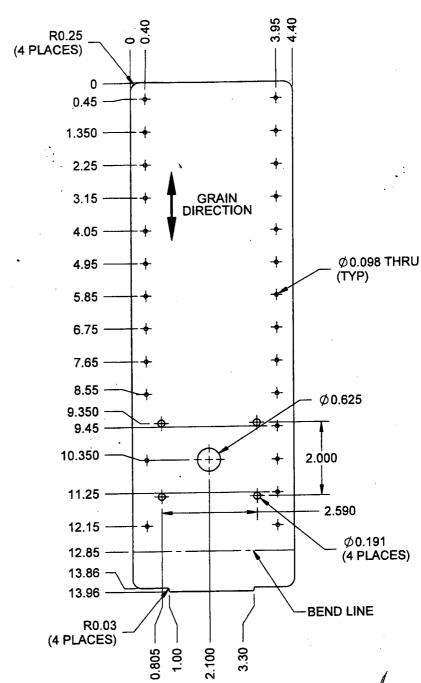
NCR:		WO	ORK OR	DER NON-CONFORMANCE	E (NCR)			-
		Description of NC		Corrective Action Section B		Verification	Annroval	Annroyal
DATE	STEP	Section A	Initial Chief Epg	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
ભીઝા <sub>ટ</sub>	上20	- 10 parts SCAP.  Wrong Program was uso  Lerelim mary not new DAN  Causing the location of the  OCS" and 0.191" holes  to be of by 0.100"  R.C. wrong Program was  USED and Humman/operator  error (water Set)	POSIONS	Scrap and clestory and Replace All parts  Remore wany programs from the net work	Start of or or	Goden of Contraction	Pasian	Er state
							S.	

Date: Tuesday, 9/11/2007 10:55:36 AM User: Chantal Lavoie **Process Sheet Drawing Name: STIFFNER Customer:** Part Number: D36393 Job Number: 34540 Job Number: Description: Seq. #: Machine Or Operation: NC BRAKE BRAKE NC 6.0 Comment: NC BRAKE Form as per Dwg D3639 INSPECT WORK TO CURRENT STEP 7.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 8.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE # 10.0 Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: FINAL INSPECTION/W/O RELEASE QC21 11.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion DISTIVE RECALL

W/O:		WORK ORDER	CHANGES	-			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	<b>:</b>	PAR #: Fault Category:	NCR: Yes	No DQ	<b>4</b> :	_ Date: _	
			QA: N	N/C Close	d:	_ Date: _	<u></u> .

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D3639-3F FLAT PATTERN (D3639-4F OPPOSITE)

NOTES: 1) MATERIAL: 2024-T3 ALÛMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037

7

(REF DART SPEC M2024T3S.050)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE PQINT PERMANENT INK MARKER

7) WEIGHT: 0.3 lbs

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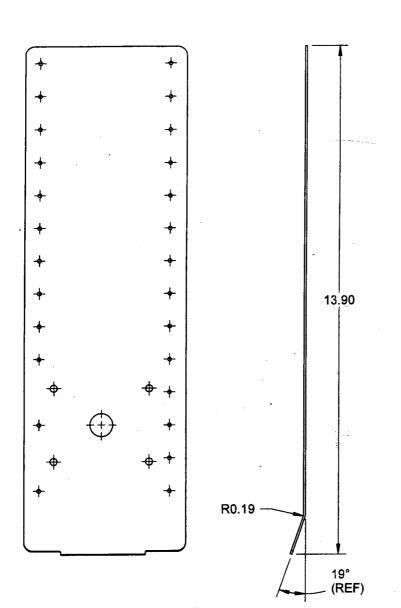
# **Dart Aerospace Ltd**

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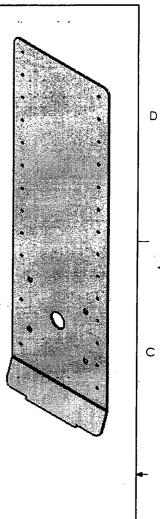
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<u>D3639-3 DOUBLER</u> (WAS GENEVA P/N G10604-4) <u>D3639-4 OPPOSITE</u> (WAS GENEVA P/N G10604-5)

# PRELIMINARY ISSUE

07-09-07 VE

DESIGN	TS L	DART AEROSPA	CE USA, INC.			
DRAWN	6	PORT HADŁOCK, WA				
CHECKED	爲	DRAWING NO.	REV. A			
MFG. APPR.	己	D3639	SHEET 2 OF 2			
APPROVED	140	TITLE	SCALE			
DE APPR.		DOUBLER	2:5			
DATE 07.0	7.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA. INC.				

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<b>Dart Aerospace Lt</b>
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W/O:		WORK ORDER C	HANGES				
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DART AEROSPACE LTD	Work Order:	34540
Description: STITTNER	Part Number:	D3639~3
Inspection Dwg: Rev: OREL		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

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Rev Date	Change	Revised by	Approved
Α	New Issue	KJ/JLM	



STIRNER Rev. PREL	### PREL Work Order: 34540  ##################################
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	Work Order: Fan Number:

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Revised by Acorama	Date: 07.09.19	wali																			Comments

# **Dart Aerospace Ltd**

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